

I claim:

1. An equipment for producing a molded article, especially a flat molded article, wherein the article has cavities and webs between the cavities and two discs essentially joined by the webs, the equipment comprising  
  
a press mold having a die for forming an outer circumference of the molded article, and a lower ram and an upper ram for forming an outer surface of the disks;  
  
a segment ram integrated in at least one of the lower ram and the upper ram, wherein the segment ram has ram segments having essentially the same cross-sectional shape as the webs, wherein the segment ram moves into and engages with the ram segments recesses having the same cross-sectional shape in the lower ram or in the upper ram, and  
  
a removable core insertable into the press mold, the removable core having the core segments for forming the cavities, wherein spaces between the core segments in the press mold are arranged congruently with the ram segments.
2. The equipment according to claim 1, wherein, for producing a ring-shaped molded article, the press mold

additionally, comprises a mandrel for forming an inner circumference of the article.

3. The equipment according to claim 2, further comprising, for producing a ring-shaped molded article having channels extending therethrough from the inner circumference to the outer circumference so as to form the cavities, a ring-shaped core centered on the die or the mandrel and adapted to the cross-section of the press mold cavity, wherein the core segments on the outer circumference and the inner circumference are held together in a grid-like manner by narrow ring segments, wherein the core can be destroyed or removed from the molded article by taking it apart.
4. The equipment according to claim 1, wherein the core has core parts configured to be removable from the molded article towards the outside and/or towards the inside, further comprising moving devices for pushing the core parts out of the die or the mandrel and for drawing the core parts into and towards the outside behind the die or into the mandrel.
5. A process for producing a molded article, especially a flat molded article, wherein the article has cavities

and webs between the cavities and two disks essentially joined by the webs, the equipment including

a press mold having a die for forming an outer circumference of the molded article, and a lower ram and an upper ram for forming an outer surface of the disks;

a segment ram integrated in at least one of the lower ram and the upper ram, wherein the segment ram has ram segments having essentially the same cross-sectional shape as the webs, wherein the segment ram moves into and engages with the ram segments recesses having the same cross-sectional shape in the lower ram or in the upper ram, and

a removable core insertable into the press mold, the removable core having the core segments for forming the cavities, wherein spaces between the core segments in the press mold are arranged congruently with the ram segments, the method comprising

filling an amount of molding compound intended for the webs, with the exception of an amount taken up by the spaces in the core, into the recesses of the lower ram with the lower ram segment being drawn back relative to

the lower ram and partially transferring the molding compound into the recesses of the upper ram by pushing forward the lower segment ram with the upper ram being lowered, and

subsequently discharging the molding compound from the recesses by simultaneously pushing forward the lower and the upper segment rams, and

finally compressing the molded article by simultaneously pushing forward the lower ram and the upper ram.

6. The process according to claim 5, comprising completely filling the molding compound intended for the webs, with the exception of the amount taken up by the spaces in the core, into the recesses of the lower ram in one operation, and, in the same operation, filling the amount intended for one of the disks, with the exception of a previously introduced lining compound, over the previously filled in compound, inserting the core, filling the spaces of the core, and in the same operation filling the amount intended for the other disk over the previously filled in compound, and subsequently

transferring the compound into the recesses of the upper ram by moving columns of material within the filling and in the spaces of the core, essentially without compression.

7. The process according to claim 6, comprising, for producing a molded article having a surface lining, filling the lining compound for one of the disks first over the continuously flat surface of the lower ram, lowering the lower segment ram, when the height of the recesses of the lower ram to be filled remain the same in and next to the recesses due to the same layer thickness of the lining compound, and wherein, finally, the lining compound for the other disk is filled in.
8. The process according to claim 5, comprising filling the amount intended for the webs, with the exception of the amount taken up by the spaces of the core, initially only partially into the recesses of the lower ram, subsequently, with the upper ram being placed on the lower ram, transferring this portion into the recesses of the upper ram, and compressing the material until it is held in the recesses of the upper ram, raising the

upper ram, and filling another portion of the amount into the recesses of the lower ram, filling the amount intended for one of the disks thereover, inserting the core thereover, filling the spaces of the core, and filling the amount intended for the other disk thereover, wherein the amounts take into account a lining compound.

9. The process according to claim 5, comprising filling an amount intended for the webs, with an addition or a deduction, completely into the recesses of the lower ram in one operation, inserting the core over the amount, or filling the amount into the spaces of the inserted core, carrying out a subsequent simultaneous discharge of the molding compound from the recesses of the lower ram and the upper ram with compression into the spaces of the core such that the molding compound is held in the spaces, and removing the core to allow the amount provided for one of the disks to be filled and reinserting the core, and filling the amount intended for the other disk thereover.

10. A process for producing a molded article, especially a

flat molded article, wherein the article has cavities and webs between the cavities and two discs essentially joined by the webs, the equipment including

a press mold having a die for forming an outer circumference of the molded article, and a lower ram and an upper ram for forming an outer surface of the disks;

a segment ram integrated in at least one of the lower ram and the upper ram, wherein the segment ram has ram segments having essentially the same cross-sectional shape as the webs, wherein the segment ram moves into and engages with the ram segments recesses having the same cross-sectional shape in the lower ram or in the upper ram, and

a removable core insertable into the press mold, the removable core having the core segments for forming the cavities, wherein spaces between the core segments in the press mold are arranged congruently with the ram segments, the method comprising

filling an amount of molding compound intended for one

of the disks over a continuously flat surface of the lower ram in one or more operations and compressing the molding compound, inserting the core, introducing an amount of molding compound intended for the webs into the spaces of the core in several operations and compressing the molding compound by the segment ram of the upper ram, and subsequently filling in the amount intended for the other disk in one or more operation and compressing the molding compound.

11. The process according to claim 10, comprising inserting at least two pieces of reinforcing fabric between the introduction of different layers of molding compound.
12. The process according to claim 5, comprising hardening the molded article by heating in the press mold.
13. The process according to claim 10, comprising hardening the molded article by heating in the press mold.